



Date: Monday, 2/12/2007 4:16:27 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 30656	
Estimate Number : 10711	
P.O. Number : N/A	Part Number : D32131
This Issue : 2/12/2007 S.O. No. : N/A	Drawing Number : D3213 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 30656	Material : N/A
Written By : 	Due Date : 2/19/2007 Qty: 8 Um: Each
Checked & Approved By : 	
Comment : Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now on Waterjet 07-02-13 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.4950 sf(s)/Unit Total : 3.9598 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)Identify as D3213-1
 Batch: M102992

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

SAD 07/02/18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/02/18

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

20702-19

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

ml 07/02/20 x8

6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------

**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.R. / a.m.

07/02/20

(8x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/02/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/12/2007 4:16:27 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30656

Part Number: D32131

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



x8

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/02/00

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA 5192*

6 7/4/01 (4)

ml 07/02/00

x4

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

6 07/02/03

Job Completion



U 07-02-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:52 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOOR ASSEMBLY
Job Number	: 30656		
Estimate Number	: 10711		
P.O. Number	:	Part Number	: D32131
This Issue	: 2/5/2007 S.O. No. :	Drawing Number	: D3213 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 2/5/2007 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25260	Material	:
Written By	:	Due Date	: 2/23/2007 Qty: 8 Um: Each
Checked & Approved By	: <u>07.02.06</u>		
Comment	: Est Rev:A New Issue 05-11-17 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M2024T3S063	2024-T3 .063 sheet
-----	-------------	--------------------



Comment: Qty.: 0.4950 sf(s)/Unit Total : 3.9598 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Identify as D3213-1
 Batch: _____

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut blanks: 15.100" x 4.500" (+0.000/-0.010)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3213-1 as per Folio FA350 and Dwg D3213
 Stack of 4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:02:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 30656

Part Number: D32131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

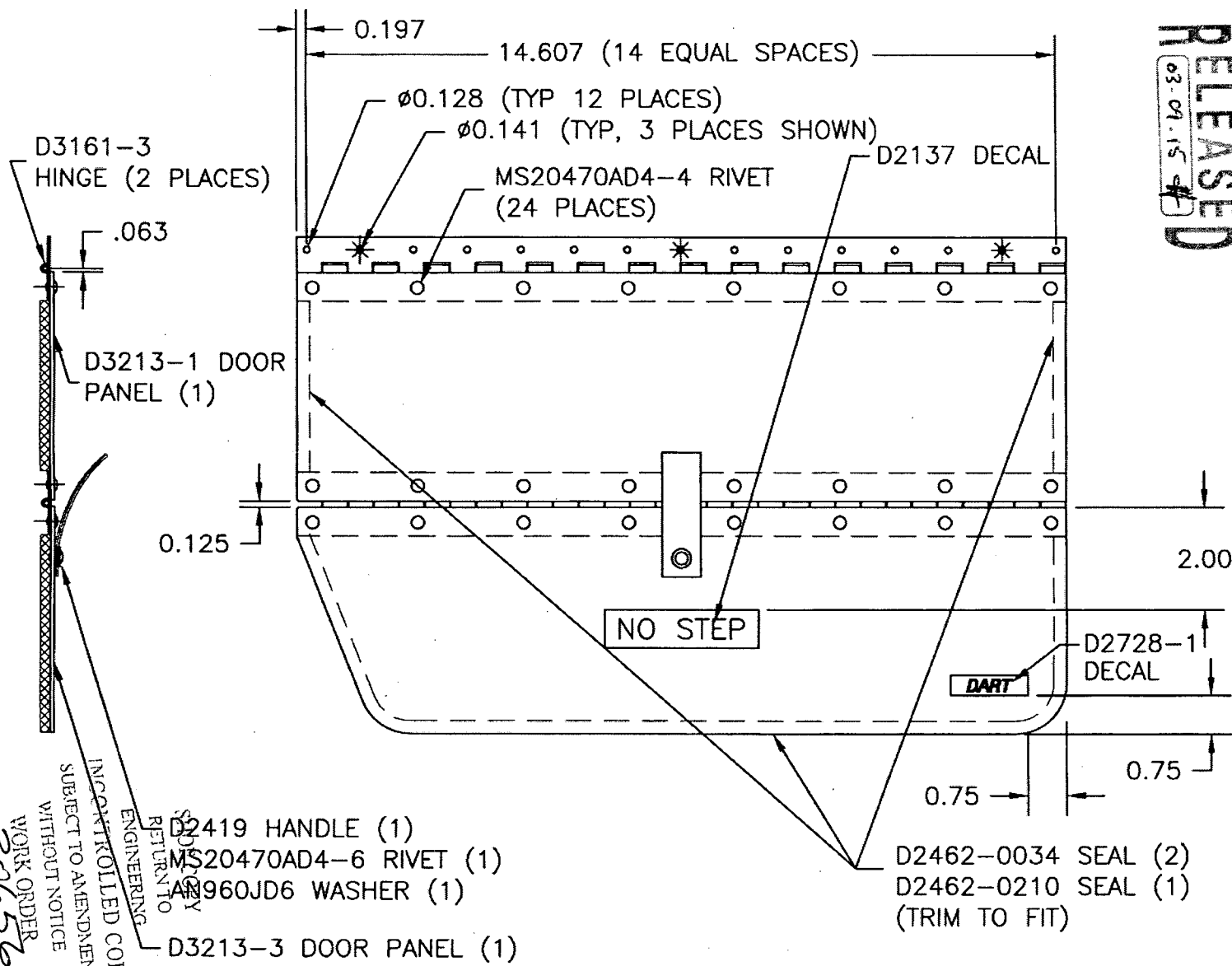
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKSBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
03.09.03	D3213	1 OF 2
	TITLE	SCALE
	DOOR ASSEMBLY	1:3
A	03.09.03	NEW ISSUE

RELEASED
03.09.15



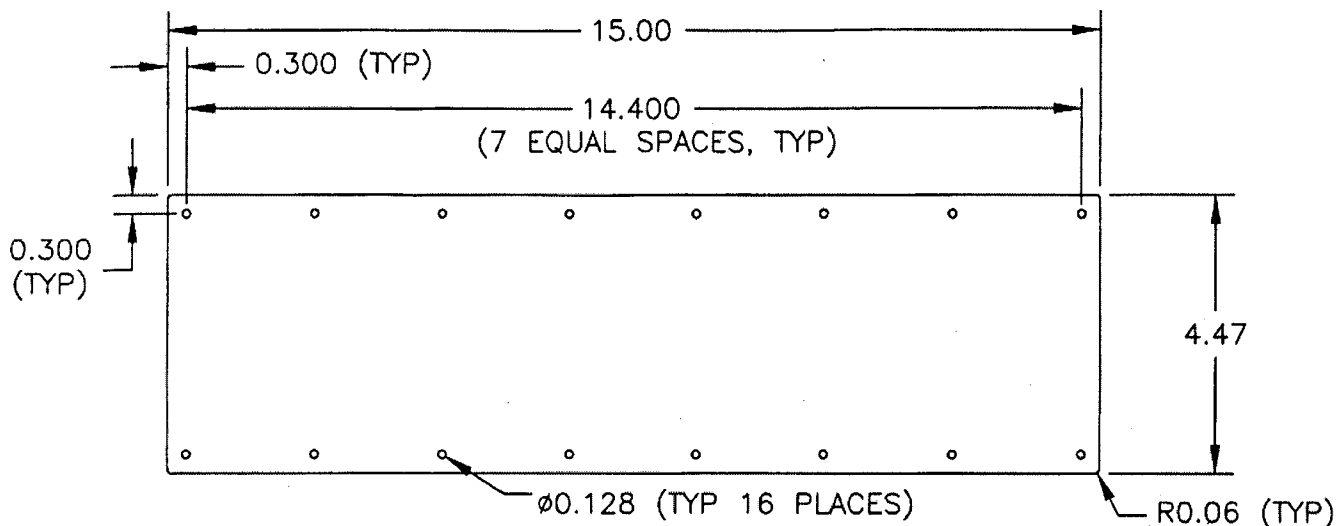
D3213-041 DOOR ASSEMBLY

FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
INSTALL D2137 DECAL, D2419 HANDLE, AND D2462 SEAL AFTER POWDER COAT
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

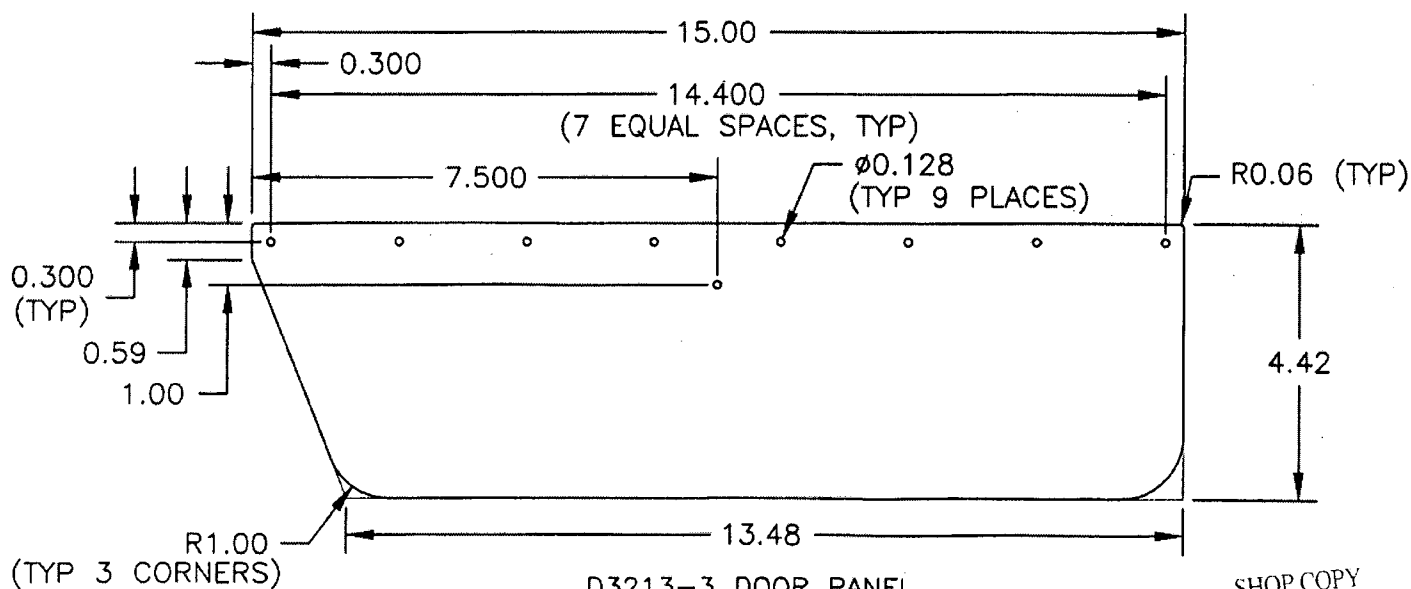
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
30652



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3213	REV. A 2 OF 2
DATE 03.09.03		TITLE DOOR ASSEMBLY	SCALE 1:3



D3213-1 DOOR PANEL



D3213-3 DOOR PANEL

D3213-1 AND D3213-3

MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
03.09.03

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 30656

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